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## Patent Abstracts of Japan

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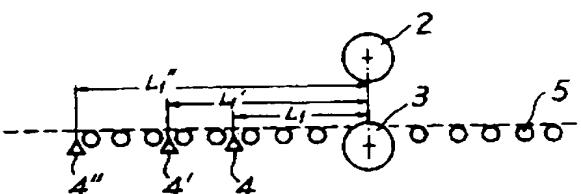
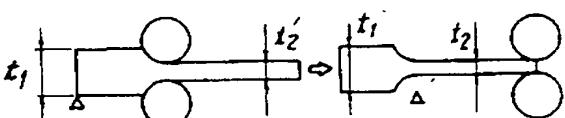
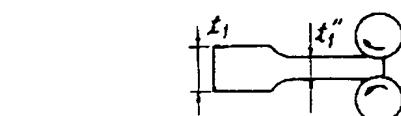
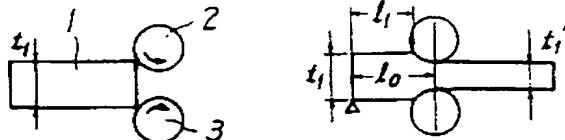
APPLICATION DATE : 08-08-83  
 APPLICATION NUMBER : 58143682

APPLICANT : KAWASAKI STEEL CORP;

INVENTOR : INOUE MASATOSHI;

INT.CL. : B21B 1/22

TITLE : ROLLING METHOD FOR PROVIDING  
 STEP DIFFERENCE TO THICK PLATE



**ABSTRACT :** PURPOSE: To roll a rolling material into a plate having a large step difference without causing turbulence in its flatness by controlling the advancing and returning rollings of the material, in rolling a rolling material by leaving a part of the material by a prescribed length and rolling the other part into a thinner one through several passes of reversing rollings.

CONSTITUTION: A steel plate 1 rolled into the sheet thickness  $t_1$  is rolled into the sheet thickness  $t_1'$  by upper and lower work rolls 2, 3 having a roll gap  $S_1$  between them, and when the top of plate 1 is detected by a steel plate detector 4, the rotation of mill is stopped to leave a thick-plate part having thickness  $t_1$  by a length  $l_1$ . Successively a return rolling is performed by reversing the mill to obtain a thin-plate part having sheet thickness  $t_1''$ . Further, the 2nd pass rolling is performed to obtain a thin plate-thickness  $t_2'$  part by regulating the roll gap to  $S_2$  ( $S_1 > S_2$ ), and the mill is reversed when the detector 4 detects the top of plate 1 to obtain a thin plate-thickness  $t_2$  part. In this way, a plate with different thicknesses is obtained, which consists of a part having a prescribed length  $l_1$  and a sheet thickness  $t_1$  and a remaining part having a sheet thickness  $t_2$ .

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